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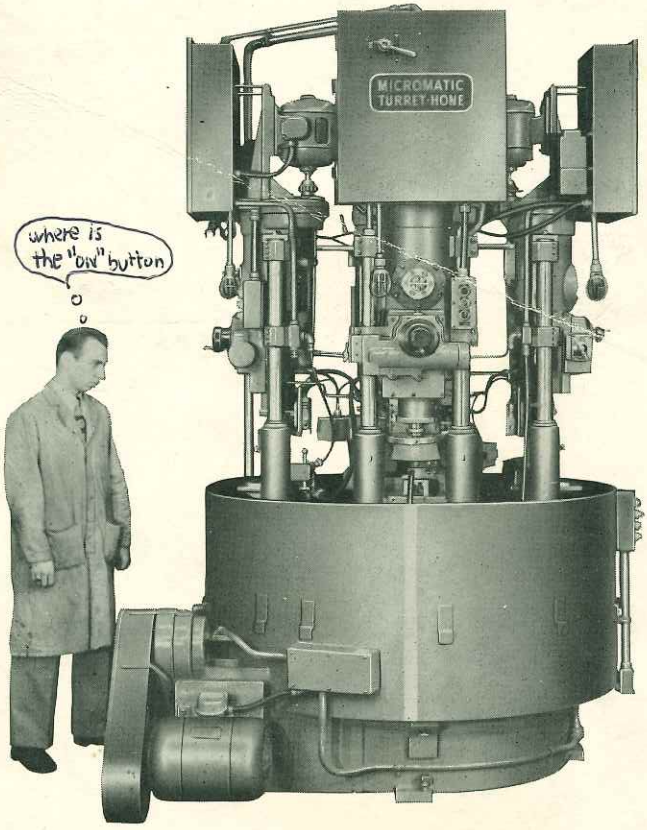
URRET-HONE
CROHONING MACHINE

51/74.2

Issued #2 Issued Machine Tools Covers & Shipping

For such high production parts as connecting rods and rocker arms four or six of the standard Model 736 MICRO-HONER head units are mounted on a base that rotates continually. The operator stands in one position loading and unloading the fixtures as they pass. The mechanical stroke of the microhoning spindle is designed to give the greatest possible rigidity and stability to the tool. It is particularly adaptable to short bores that require bore-to-face squareness.



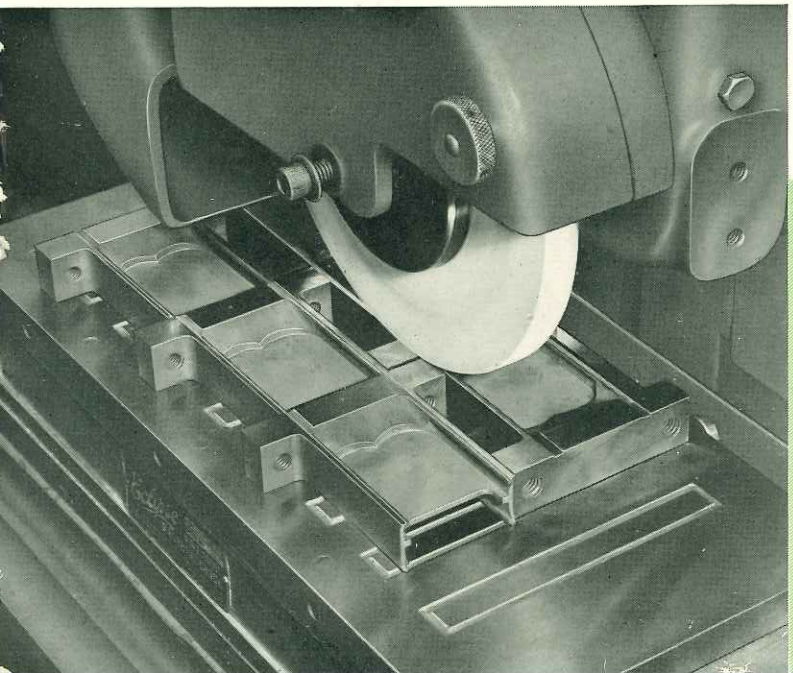
The machines may be equipped with MICRO-SIZE control holding close tolerance on size automatically. This is made possible by moulding the abrasive stick into a plastic case, which actuates the MICROSIZE control ring as the bore reaches its predetermined size.

MICROHONING TOOLING AND ABRASIVES

Microhoning is an abrading process used to shear stock from cylindrical surfaces. A number of abrasive sticks are mounted about the body of the tool. As the tool is expanded these sticks are forced out radially with equal pressure in all directions. Microhoning tools are available for cylinders of any size from ·070″ to 40″ diameter and 75 feet or more in length.

Micromatic Abrasive Tooling can be designed for any specific application on Micromatic Honing Machines.

The above illustration shows a battery of our Model 540 Surface Grinders in operation at the Gillette works engaged on grinding punches and dies. These are manufactured from tungsten carbide, high carbon—high chrome steel and are ground to very precise limits. This is a typical application for our Model 540 Surface Grinder which has the necessary sensitive adjustments for grinding to precise tolerances.



Close up of one of the Jones-Shipman Model 540 Surface Grinders grinding dies for Gillette razors.

PRECISION GRINDING PUNCHES AND DIES FOR GILLETTE RAZORS

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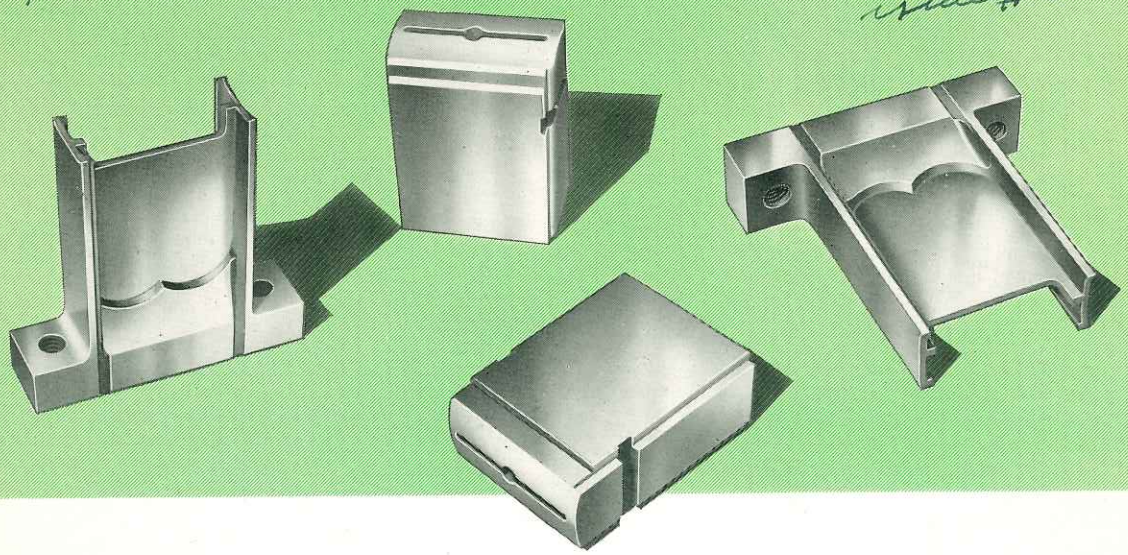
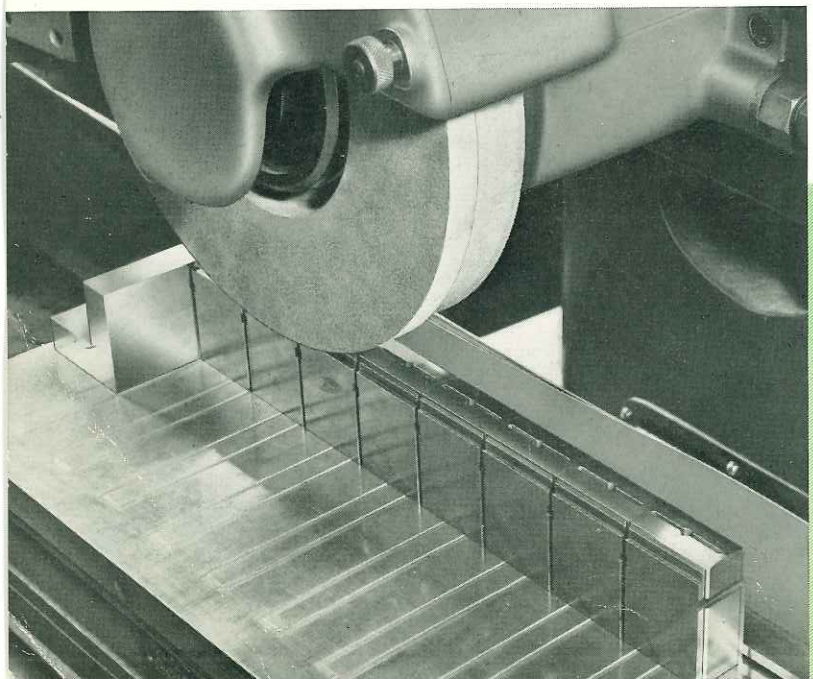
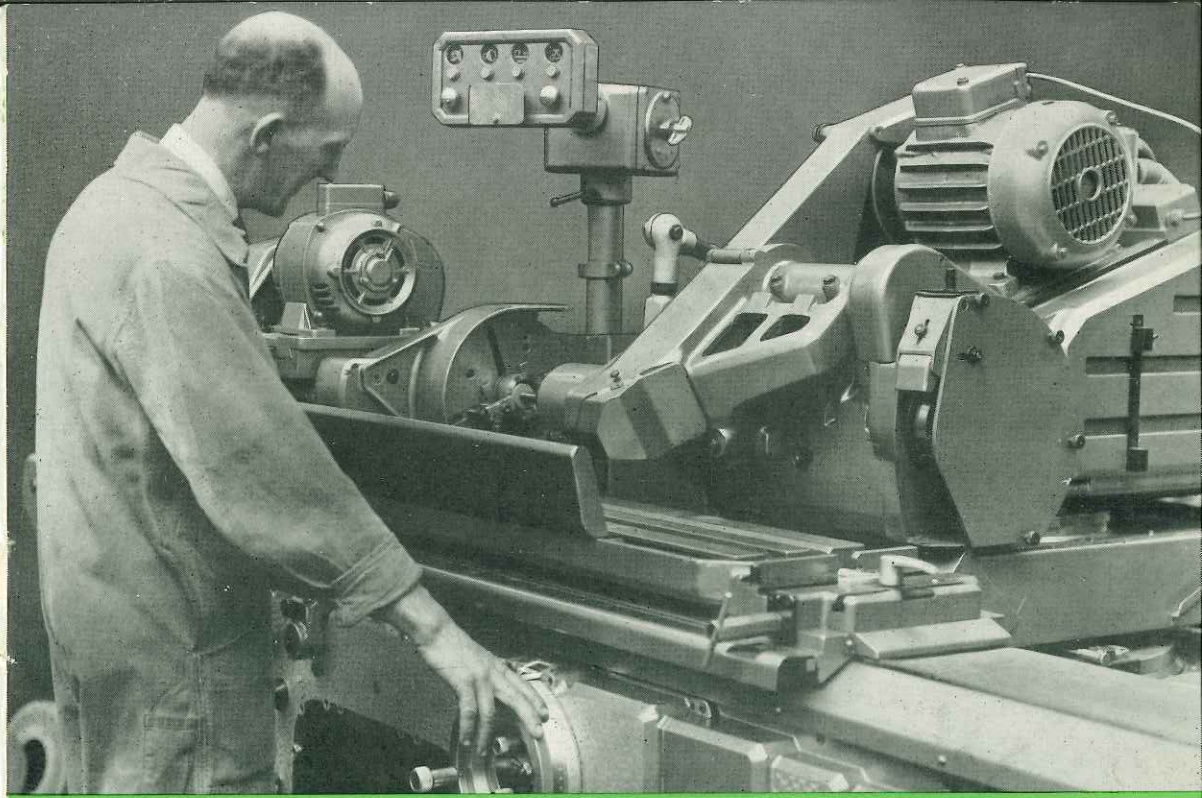


The production of the world famous safety razors and blades by Gillette Industries Ltd., Isleworth, Middlesex, necessitates very exacting manufacturing methods. The quantity produced daily is astronomical and therefore, to satisfy this continuous demand, a constant supply of punches and dies are required. These punches and dies, illustrated above, are precision ground on Jones-Shipman Surface Grinders.

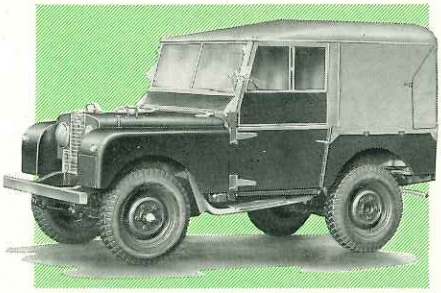


Form grinding a series of punches on a Jones-Shipman Model 1011 Surface Grinder.



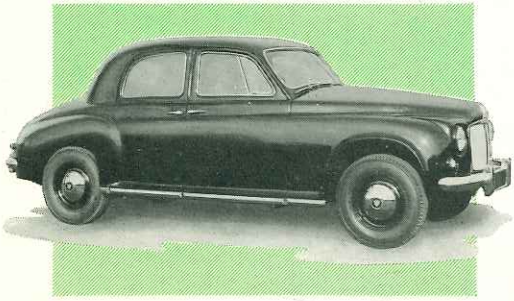
TOOL ROOM GRINDING FOR ROVER PRODUCTION CARS

A number of Jones-Shipman precision machines are installed in the Toolroom at the works of the Rover Company Limited, Birmingham, and are engaged in producing gauges, tools and fixtures which play a vital part in the economical output of their standard production vehicles, the Rover " 75 " and the popular and versatile Land-Rover. The illustration at the top of the page shows a standard Jones-Shipman semi-universal hydraulic grinder set-up for grinding setting gauges for cylinder blocks.



LAND-ROVER

ROVER " 75 "



Other Jones-Shipman grinding machines which are in constant use in the Toolroom at the Rover works include several of our Model 540 6″ × 18″ capacity Surface Grinders and Model 310 8″ × 16″ Cutter and Tool Grinders.